

Date: Monday, 7/16/2007 2:48:02 PM  
User: Kim Johnston

# Process Sheet

*SPIT*

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 33566 *3*  
Estimate Number : 10012  
P.O. Number : *N/A*  
This Issue : 7/16/2007 S.O. No. : *N/A*  
Prsht Rev. : *NC*  
First Issue : *N/A* Type : LARGE FAB ASSY  
Previous Fun : 33082

Drawing Name : LUG ASSEMBLY  
Part Number : D27363  
Drawing Number : D2736 REVA  
Project Number : N/A  
Drawing Revision : A  
Material : *N/A*  
Due Date : 8/5/2007

Qty: *27* Um: Each

Written By : *[Signature]*  
Checked & Approved By : *[Signature]* 07.07.17  
Comment : Est Rev: D Removed from 9 digit 05-10-25 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2591

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2591 Lug

*D24829*

*FC 07/11/08*

*(40)*

2.0

D27353

Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2735-3 Lug Bracket

*D34920 x24*  
*D33569 x16*

*FC 07/11/08*

*(40)*

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: *m9326*

*FC 07/11/08*

*(40)*

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-11-08 (40)*

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Carbon*  
*5/27/09 (40)*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 33566

Part Number: D27363

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M105194



(34X)

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M/S 07/11/12  
JSS 07-01-09

(X6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 7/11/09 (40)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST471

AS 07/11/12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

A 07/11/14

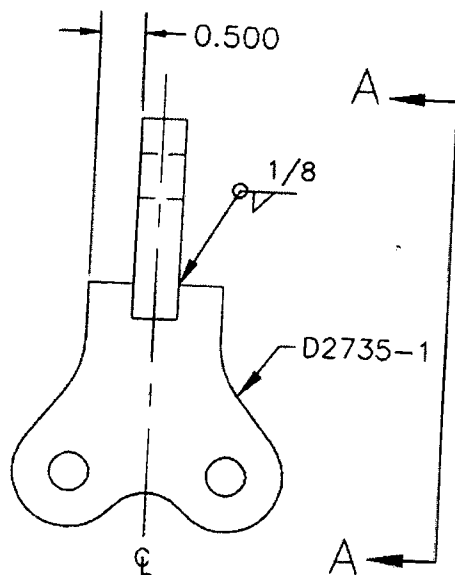
Job Completion



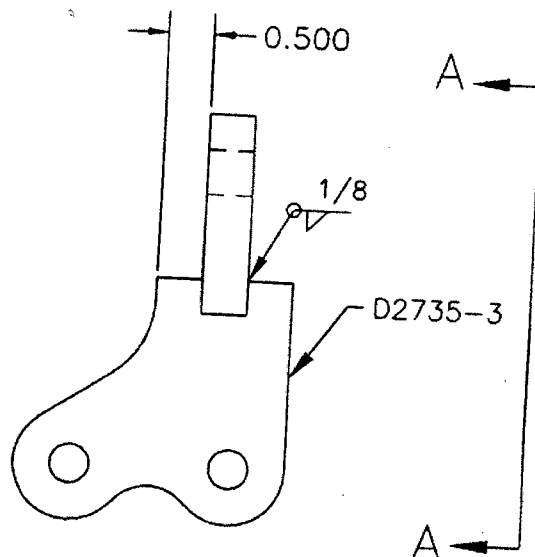
L 07.11.13



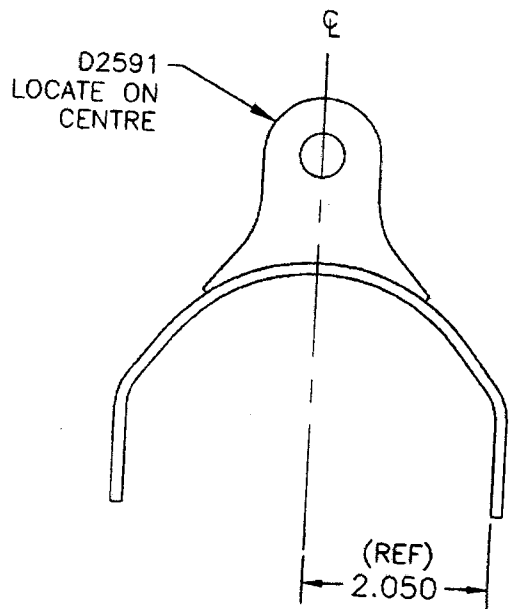
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.  
PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)

**RELEASED**

97/12/24

ECN 057

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 33566